

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010775**Date Inspected:** 16-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 6AW/6BW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BP140-001-029, 031. The welder is identified as #066674 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG029C-006. The welder is identified as #220067 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-T-2234-C-U2-F.

This QA Inspector observed back gouging of the CJP root pass of the Longitudinal Diaphragm flange to Floor Beam connection at panel point 44 west, cross beam side.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 6BE/6CE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP517-001-007. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-3213-B-U3b.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as DP363-001-023, 024, 025. The welder is identified as #048659 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-3213-B-U3b.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BP114-001-022, 024, 026. The welder is identified as #220069 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-T-2233-B-U2-F.

This QA Inspector observed grinding of the back gouged CJP Edge Plate splice, cross beam side.

Segment 6CE

This QA Inspector observed fit up of the traveler rail bracket to the Side Plate, bike path side.

Segment 6BE

This QA Inspector observed match drilling of bolt holes in the Deck Plate U-ribs for splice plate connection at panel point 41.

Segment 6CE

This QA Inspector observed trimming of the FL3 at panel point 46 at cross beam connection.

Segment 6CW

This QA Inspector observed trimming of the FL3 at panel point 46 at cross beam connection.

ZPMC Quality Control (QC) Inspector is identified as Song Hui. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan
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Quality Assurance Inspector

Reviewed By:	Miller,Mark
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QA Reviewer
